



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4634-3
Job Sheet 185099



Part No: D4634-3

Job Qty: 4 ea

Part Name: Middle, Center Ceiling Panel



DAS
21
9-89

Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/22/18

Job Tracking No:

Due Date: 11/23/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV G SHEETS 12,13,16,17 IPP Rev. A 12/08/09 New Issue DL IPP Rev B 12/11/08 Document release
DL VERIFIED BY:JLM IPP Rev C 13/07/09 Dwg Update DL ver: DD IPP Rev D Dwg Update 13/12/23 DL IPP
REV E Dwg update 14/01/09 DL IPP Rev F Dwg. update 14/02/03 DL IPP Rev G Dwg. Update 15/01/27 DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Purchasing	4 pcs	11/23/18	11/23/18	0.00	0.00	Purchasing		NOV 23 2018
140	Packaging	4 pcs	11/23/18	11/23/18	0.00	0.00	Packaging2		NOV 23 2018
150	QC	4 pcs	11/23/18	11/23/18	0.00	0.00	QC6		38
170	Packaging	4 pcs	11/23/18	11/23/18	0.00	0.00	Packaging3	16.234	DAS 9-89
180	QC21-SA	4 Ea	11/23/18	11/23/18	0.00	0.00	QC21		21 NOV 27 2018

Part Op 140 - Receive & Inspect for Damage & Mat'l Certs
Descriptions: 150 - QC6- All purchased or subcontracted products
170 - Identify as per dwg & Stock Location:
180 - QC21- Final Inspection - Work Order Release

PO 041442 Oct 24. 2018 x4

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4634-3P	Middle, Center Ceiling Panel	4 pcs (1 ea)	110-Purchasing	5131083
MLEXS.093-F6006-07	GE Plastics Lexan Sheet (Light Grey)	69.3200 sf (17.33 ea)	110-Purchasing	5131084

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Purchasing	D4634-3P	4	1	0
	MLEXS.093-F6006-07	69	1,735	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

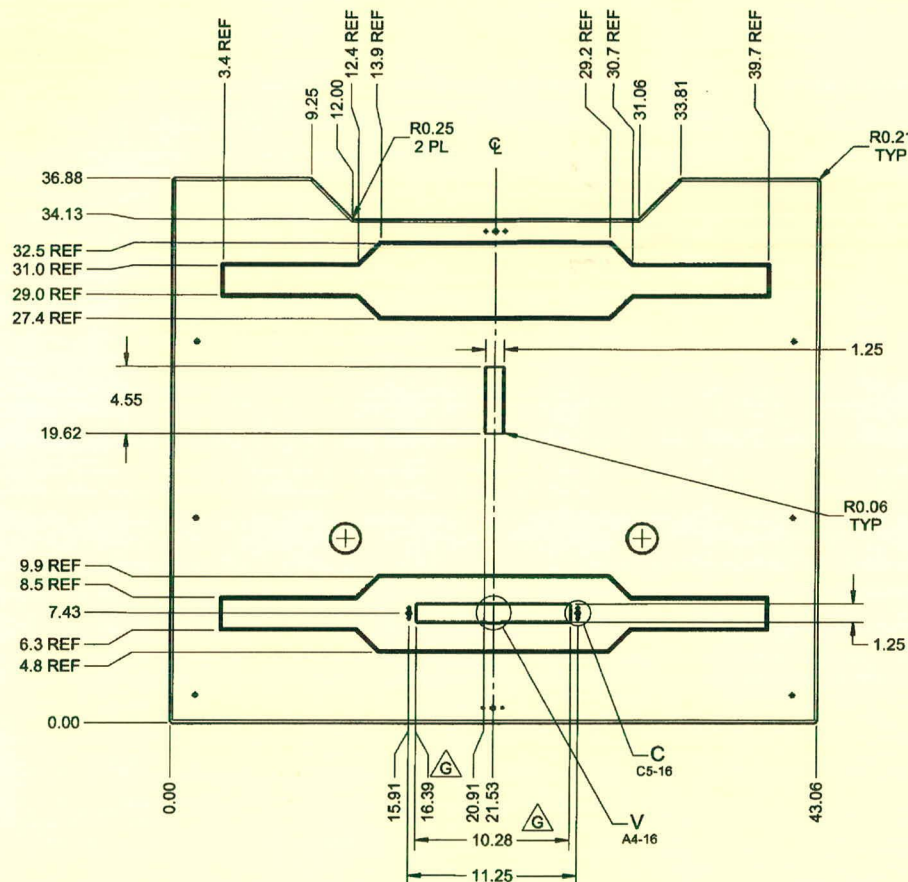
WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval			
Description Work Order Deviation				Disposition					
								Completed By	
Root Cause									
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	 Container No: S131085 DART AEROSPACE 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com Dart Aerospace Ltd. Packaging Revision: _____ Operation: _____ Change No: _____ PART NO: D4634-3 Serial No/Batch: S131085 Operation: _____ Revision: _____ Change No: _____						
Design ☐	☐ Operator	☐ Bending							
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric							
Equip/Tooling ☐	☐ Supplier	☐ Cracks							
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Weld							
Material ☐	☐ Use for Testing	☐ Cuffs							
Internal Transport ☐	☐ Poor Information	☐ Crushing							
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat							
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube							
Substation ☐	☐ Process Improvement	☐ Marks/Chatter							
Past Expiry Date ☐	☐ Manufacturing Process								
Misidentified ☐	☐ Past Due	☐ OTHER : _____							



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 185099ML5
181022

NOTES:
1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)

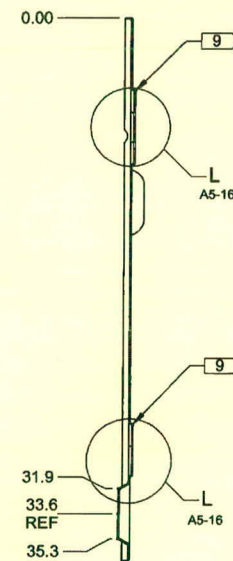
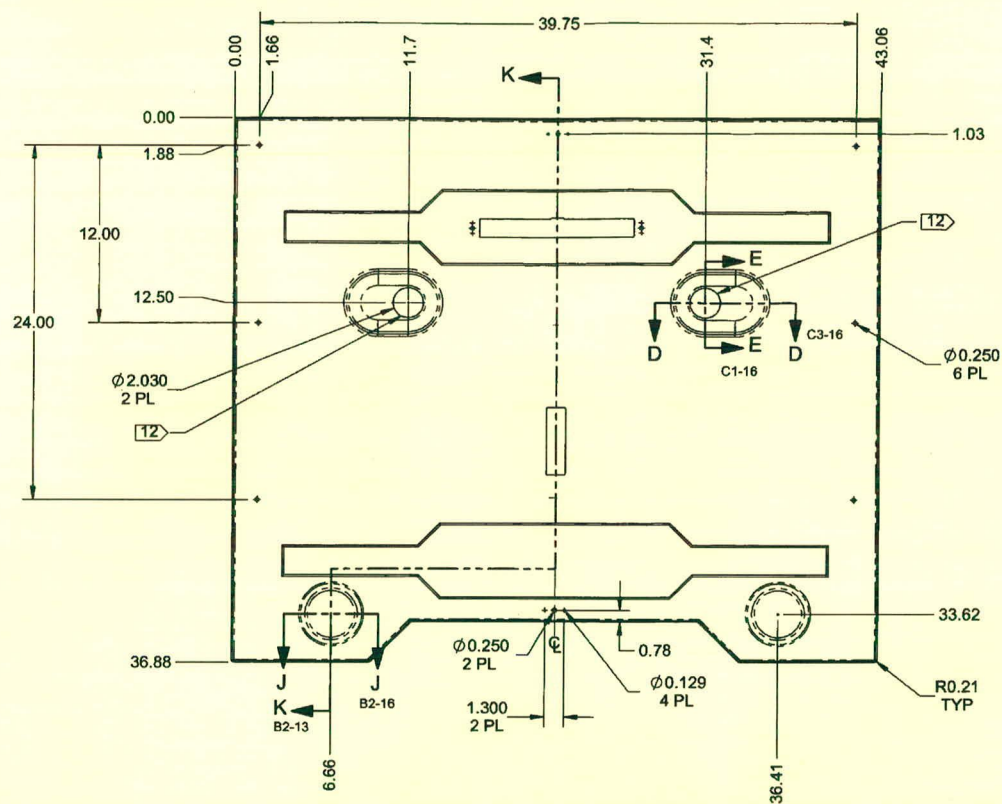
D4634-3 MIDDLE, CENTER CEILING PANEL

- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 6.49 lbs
- 8) TEXTURE ON THIS SIDE
- 9) 0.14 RADIUS NOT SHOWN FOR CLARITY
- 10) DRILL & TRIM D4634-3 PER TOOL DT9837
- 11) THERMOFORM PER QSI 022 USING DT9845 TOOL
MIN. THICKNESS AFTER FORMING:
EDGES = 0.060
ELSEWHERE = 0.070
- 12) LOCATE Ø2.030 AT CENTER OF PROTRUDED SURFACE AS SHOWN

RELEASED
2015 JAN 26

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	AK	DRAWING NO.	REV. G
MFG. APPR.	DL	D4634	SHEET 12 OF 17
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CENTER CEILING PANELS	NTS
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SECTION K-K B6-13

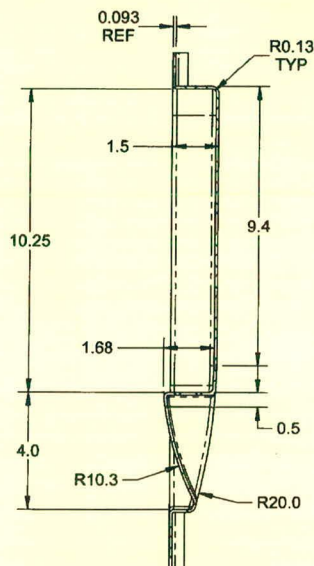
D4634-3 MIDDLE, CENTER CEILING PANEL
AUXILIARY VIEW

RELEASE
2015 JAN 26 *up*

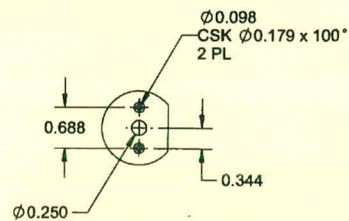
APPROVED

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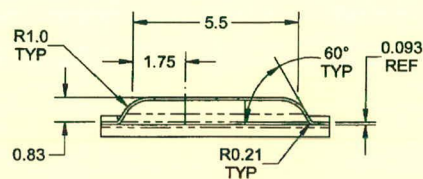
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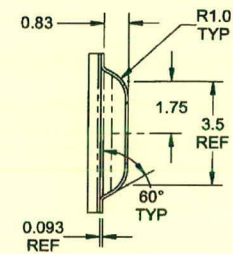
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SCALE 4X



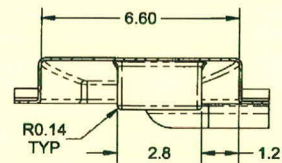
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SCALE 4X B4-12
B4-14



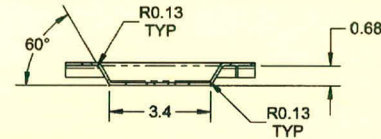
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C4-15



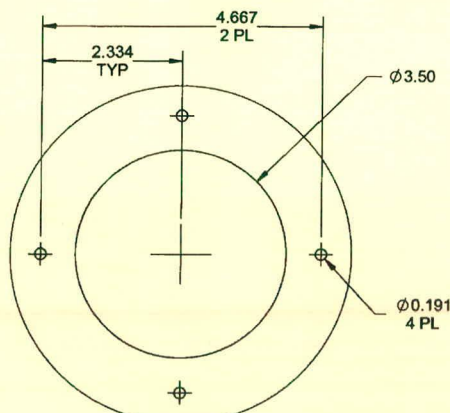
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SCALE 4X C4-13
C5-15



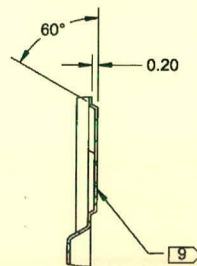
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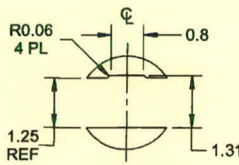
SECTION J-J B6-13
SCALE 2X



DETAIL B B7-10
SCALE 4X
2 PL



DETAIL I B2-13
SCALE 4X TYP C2-13
B2-14
C2-14



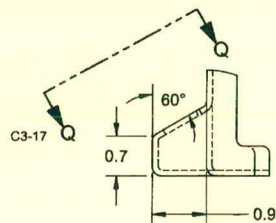
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SCALE 2X B4-12
SIMILAR C4-14

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2015 JAN 26

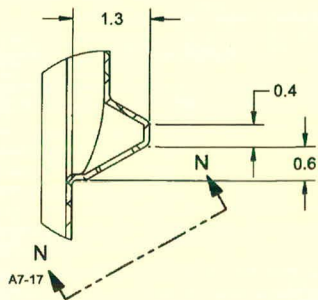
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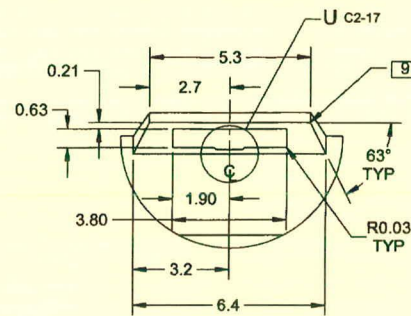
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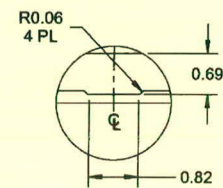
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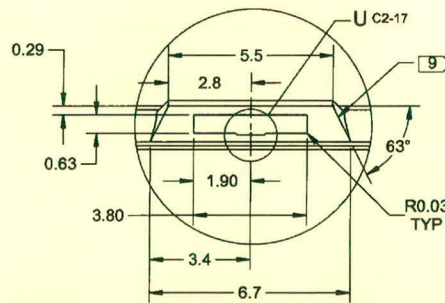
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SCALE 2X



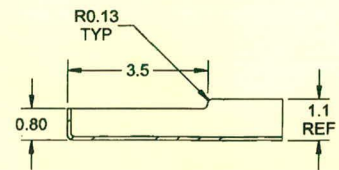
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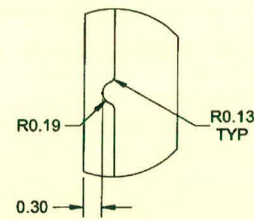
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SCALE 0.5X D3-17



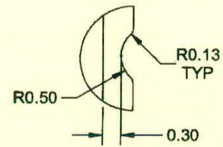
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SCALE 0.5X B4-15



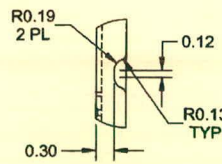
SECTION O-O B6-14
SCALE 1.3X



DETAIL R B3-10
SCALE 4X C3-10
B2-12



DETAIL S B3-10
SCALE 4X C2-12



DETAIL T C2-14
SCALE 4X

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2015 JAN 26

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CHECKED	AK	DRAWING NO.	REV. G
MFG. APPR.	DL	D4634	SHEET 17 OF 17
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041442**

Supplier: PLA002-VC
Plas-Tech
115 Applewood Crescent
Concord
ON
L4K 5C1 Canada
Phone: 416-736-0004
Fax: 416-736-0010

PO No: PO041442
PO Date: 10/24/18
Due Date: 11/21/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Lussier, PatrickPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Revision

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	185086	D4635-1P			Fwd Ceiling Panel, LH : Various STC's As Per Dwg D4635 Rev. F	Firmed	-	11/21/18	5 pcs	0 pcs	5 pcs	\$225.00/pcs	\$1,125.00
2	185089	D4635-3P			Aft Ceiling Panel, LH : Various STC's As Per Dwg D4635 Rev. F	Firmed	-	11/21/18	5 pcs	0 pcs	5 pcs	\$225.00/pcs	\$1,125.00
3	185093	D4635-2P			Fwd Ceiling Panel, RH : Various STC's As per Dwg D4635 Rev. F	Firmed	-	11/21/18	5 pcs	0 pcs	5 pcs	\$225.00/pcs	\$1,125.00
4	185094	D4634-1P			Fwd, Center Ceiling Panel : Various STC's As Per DWG D4634 REV. G	Firmed	-	11/21/18	5 pcs	0 pcs	5 pcs	\$225.00/pcs	\$1,125.00
5	185099	D4634-3P			Middle, Center Ceiling Panel : Various STC's As Per Dwg D4634 Rev G	Firmed	-	11/21/18	5 pcs	0 pcs	5 pcs	\$225.00/pcs	\$1,125.00
6	185101	D4634-5P			Aft, Center Ceiling Panel : Various STC's As Per Dwg D4634-5 Rev. G	Firmed	-	11/21/18	5 pcs	0 pcs	5 pcs	\$225.00/pcs	\$1,125.00
7	185823	D4635-4P			Aft Ceiling Panel, RH : Various STC's As Per Dwg D4635 Rev. F.	Firmed	-	11/21/18	5 pcs	0 pcs	5 pcs	\$225.00/pcs	\$1,125.00

Grand Total: \$7,875.00

DAS
38
9-96



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
PO041442

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Plex 11/2/18 2:35 PM dart.Lussier.Patrick

Packing Slip

PLAS-TECH
Think Plastics_{inc.}

115 Applewood Crescent
Concord, ON, L4K 5C1
PLASTECHONLINE.COM
P- 416 736 0004
F- 416 736 0010

Shipment Number: 32545
Shipment Date: 11/22/2018
BOL Number:
Customer Key: C1887
Salesperson: MIKE AUBE
Page Number: 1 of 1

B DART AEROSPACE LTD.
I 1270 ABERDEEN STREET
L HAWKESBURY ON K6A 1K7
L CA
T Attn: DALE BATES
O Buyer Contact: PATRICK LUSSIER

S DART AEROSPACE
H 1270 ABERDEEN STREET
I HAWKESBURY ON K6A 1K7
P CA
T Attn: PATRICK LUSSIER
O

Purchase Order

41442

Sales Order

SO-026069

Incoterms

EX WORKS

Payment Method

COL

Carrier Account #

151793240

Ship Via

FEDERAL EXPRESS - Priority Overnight

Tracking Number

Item Number Revision	Description	Quantity Shipped	UOM
D4634-1P - Rev.: G	FWD, CENTER CEILING PANEL	5	EA
D4634-3P - Rev.: G	MIDDLE, CENTER CEILING PANEL	5	EA
D4634-5P - Rev.: G	AFT, CENTER CEILING PANEL	5	EA

DAC
38
9-08

Number of Containers

Gross Weight

Shipped By

Certificate Of Conformance



Customer: DART AEROSPACE LTD P.O. # 41442 ✓ SO # 026069

Part #	<u>4634-1P</u> ✓	Qty.	<u>5</u> ✓	Batch #	<u>-004</u>
Description	<u>FWD, CENTER CEILING</u> <u>PANEL</u>	Material usage	<u>3 SHEETS</u>	Lot#	<u>DART0116</u> <u>0007424014</u>
Part #	<u>4634-3P</u> ✓	Qty.	<u>5</u> ✓	Batch #	<u>-005</u>
Description	<u>MIDDLE, CENTER CEILING</u> <u>PANEL</u>	Material usage	<u>3 SHEETS</u>	Lot#	<u>DART0116</u> <u>0007424014</u>
Part #	<u>4634-5P</u> ✓	Qty.	<u>5</u> ✓	Batch #	<u>-006</u>
Description	<u>AFT, CENTER CEILING</u> <u>PANEL</u>	Material usage	<u>3 SHEETS</u>	Lot#	<u>DART0116</u> <u>0007424014</u>
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	

Note: All parts are not identified as meeting QSI044.

By: AS Date: Nov. 22, 2018 COFC # 091
(Approved QA Signatory)

DAS
38
9-88

Page: 1 of 1

Plas-Tech Inc. 115 Applewood Cres. Concord, Ontario L4K 5C1 Tel: (416) 736-0004 Fax: (416) 736-0010

Email: info@plasteconline.com, Web: www.plasteconline.com

